

Work Order ID 52316

Tuesday, September 22, 2009 2:51:46 PM



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Item ID: D3065-3	Accept		Setup Start	
Revision ID: B			Stop	
Item Name: Step Spacer				
Start Date: 9/23/2009	Start Qty: 40.00		Cust Item ID:	
Required Date: 10/9/2009	Req'd Qty: 40.00		Customer:	
Reference:				

Approvals:	Process Plan: <u><i>PL</i></u>	Date: <u>09-22</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100 0.00
 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Deburr if necessary

9-11-3

Ph

110 0.00
 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

9-11-3

42

120 0.00
 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

Sortaloy

100%
40
HISCON
hsk
at 41
Per
template
8

W/O: 52316		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/11/14	120	Test qty +1 for template for inspection	<i>[Signature]</i>	09-11-09	1	<i>[Signature]</i> 09-11-09	<i>[Signature]</i> 02/11/14

Part No: D3065-3 PAR #: Fault Category: Small Job / W.J NCR: Yes No DQA: *[Signature]* Date: 05-11-18
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: *[Signature]* Date: 05-11-18

NCR: 52316		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/11/14	100	Found Qty +1 Part with the hole location not aligning * Part moved during w/3 R.C. Process 2	<i>[Signature]</i> 09-11-14	= Scrap + Destroy No Replace qty +1	<i>[Signature]</i> 9-11-14	<i>[Signature]</i> 02/11/14	<i>[Signature]</i> 09-11-18	<i>[Signature]</i> 02/11/14

NOTE: Date & initial all entries

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Accept

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Start Date: 9/23/2009 Start Qty: 40.00

Required Date: 10/9/2009 Req'd Qty: 40.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
	Memo	0.00							
	Deburr Stack								
140  Brake NC	NC BRAKE	0.00							
	Memo	0.00							
	Bend as per Dwg D3065								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

N/A done @ 100%

SB 09/11/09

40 0






410
counted



09-11-09




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Required Date:	10/9/2009	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>u</i>	<i>09/10/11</i>		<i>(40x)</i>	<i>(2)</i>		
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>BF</i>	<i>09-11-10</i>		<i>(40)</i>			
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>G-A</i> Memo	0.00 0.00				<i>EF 09/11/10</i>	<i>(40)</i>		

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Item ID: D3065-3

Accept

Revision ID: B

Item Name: Step Spacer

Start Date: 9/23/2009 Start Qty: 40.00

Required Date: 10/9/2009 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/10

mf
09-11-10

Picklist Print

Tuesday, September 22, 2009 2:51:45 PM

Page 1

Work Order ID: 52316



Parent Item: D3065-3RevB



Parent Item Name: Step Spacer


Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	220.2565	9.1705			



B 9-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

220.2564789

110337

6.4

111786

39.0665789

112291

91.9258

112331

82.8641

112291

DART AEROSPACE LTD		Work Order: 52316
Description: Step Spacer		Part Number: D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

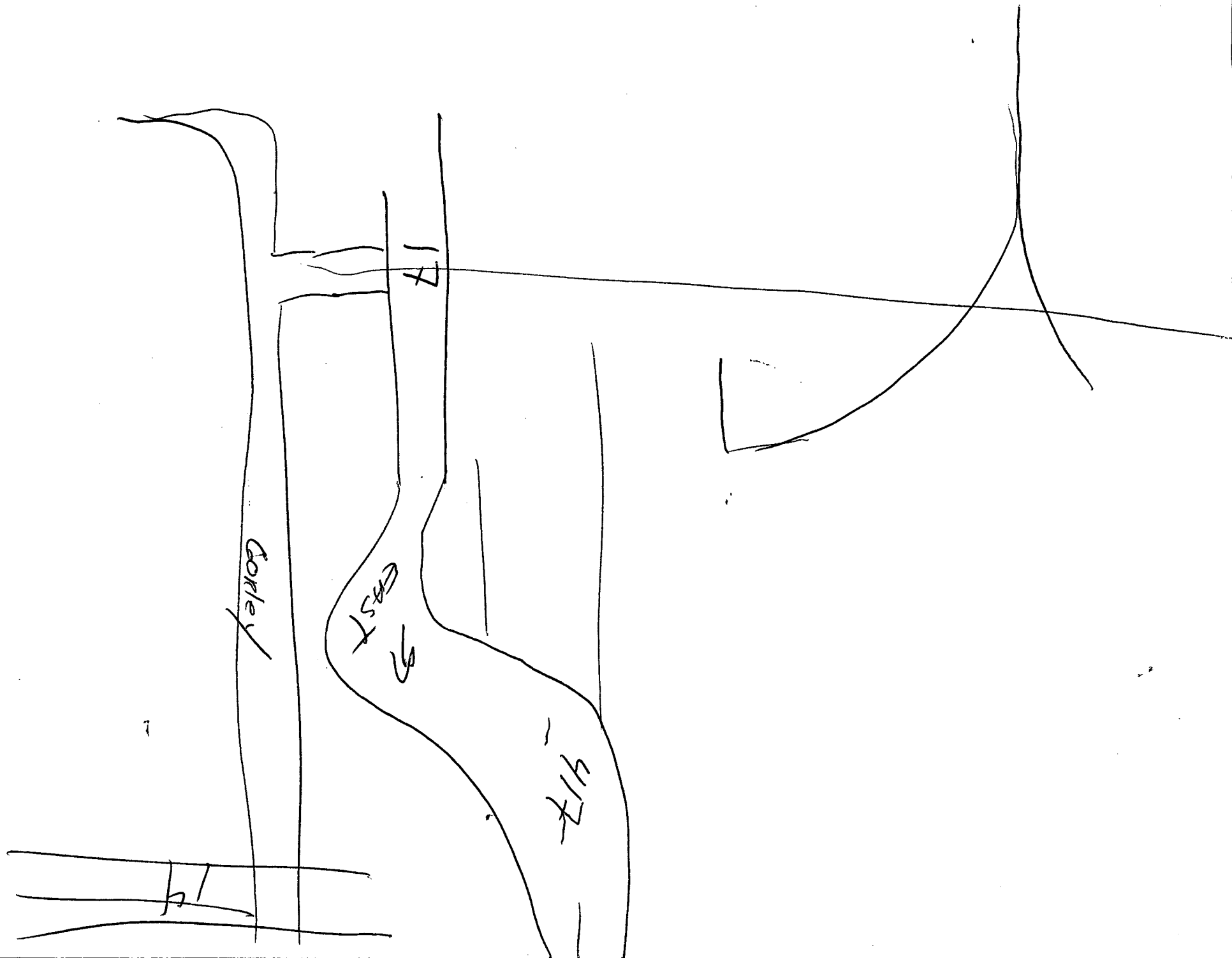
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.257	*			
3.260	+/-0.010	3.258	*			
5.260	+/-0.010	5.260	>			
6.520	+/-0.010	6.522	*			
2.093	+/-0.010	2.090	*			
3.936	+/-0.010	3.940	>			
4.186	+/-0.010	4.187	*			
Ø0.128	+0.005/-0.000	.132	*			
Ø1.250	+0.005/-0.000	1.252	*			
Pitch 1.204	+/-0.005	1.207	*			
0.040	+/-0.010	.040	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-3	Date: 01/11/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	BE



SHOP COPY
RETURN TO

UNCO

DART

SUBJECT TO AMENDMENT

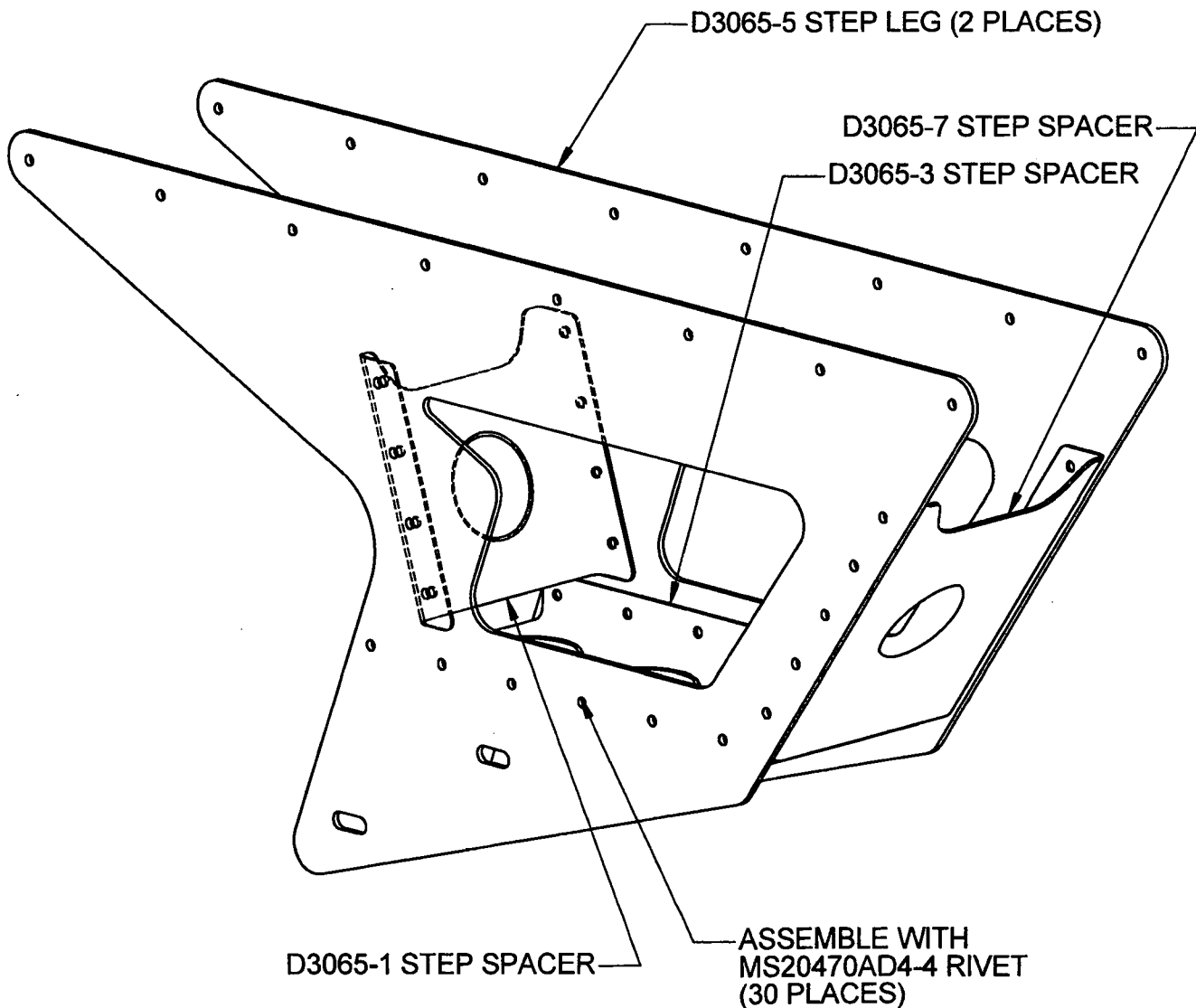
WITHOUT NOTICE
WORK ORDER

NO. 52316

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

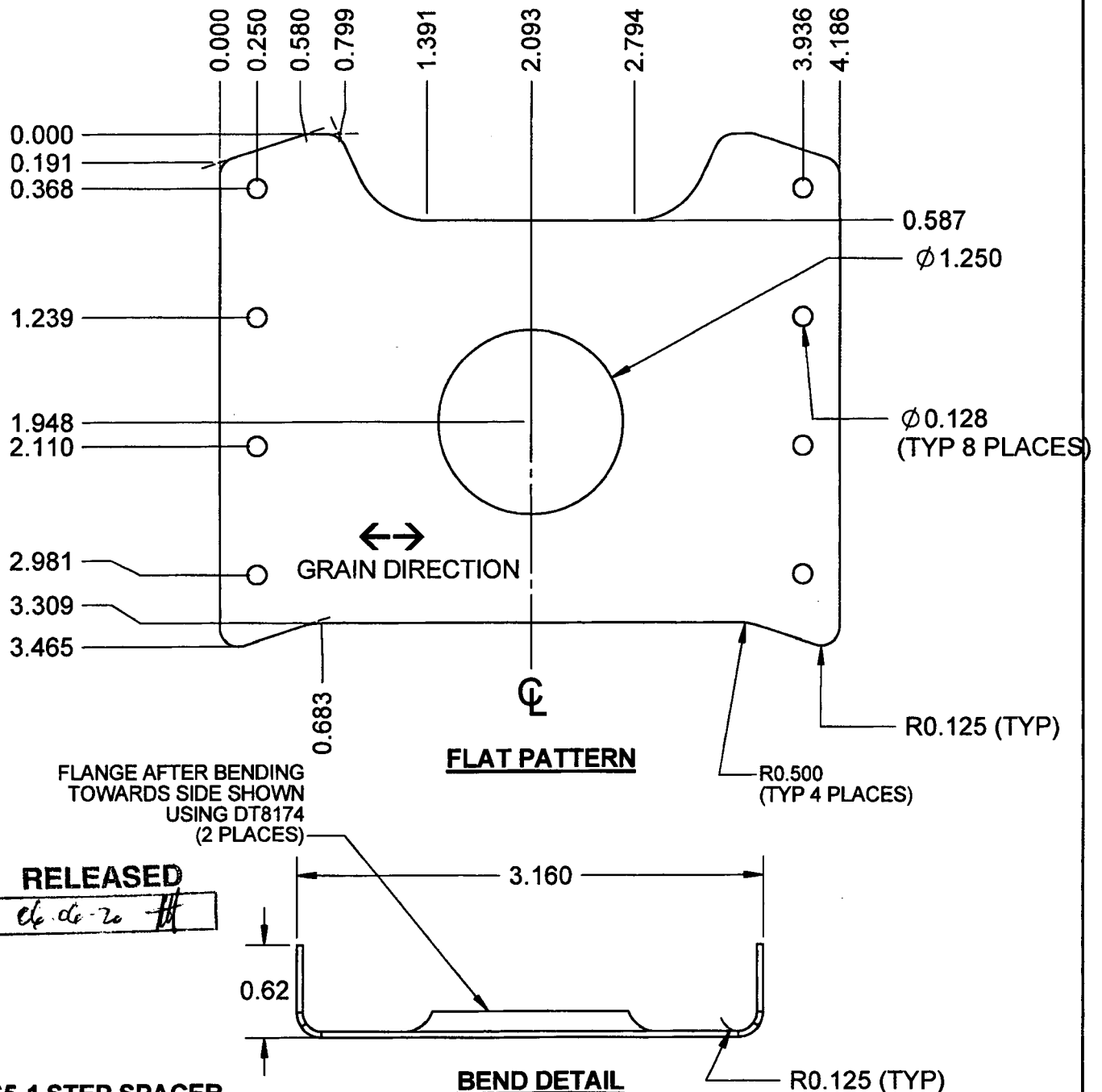
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



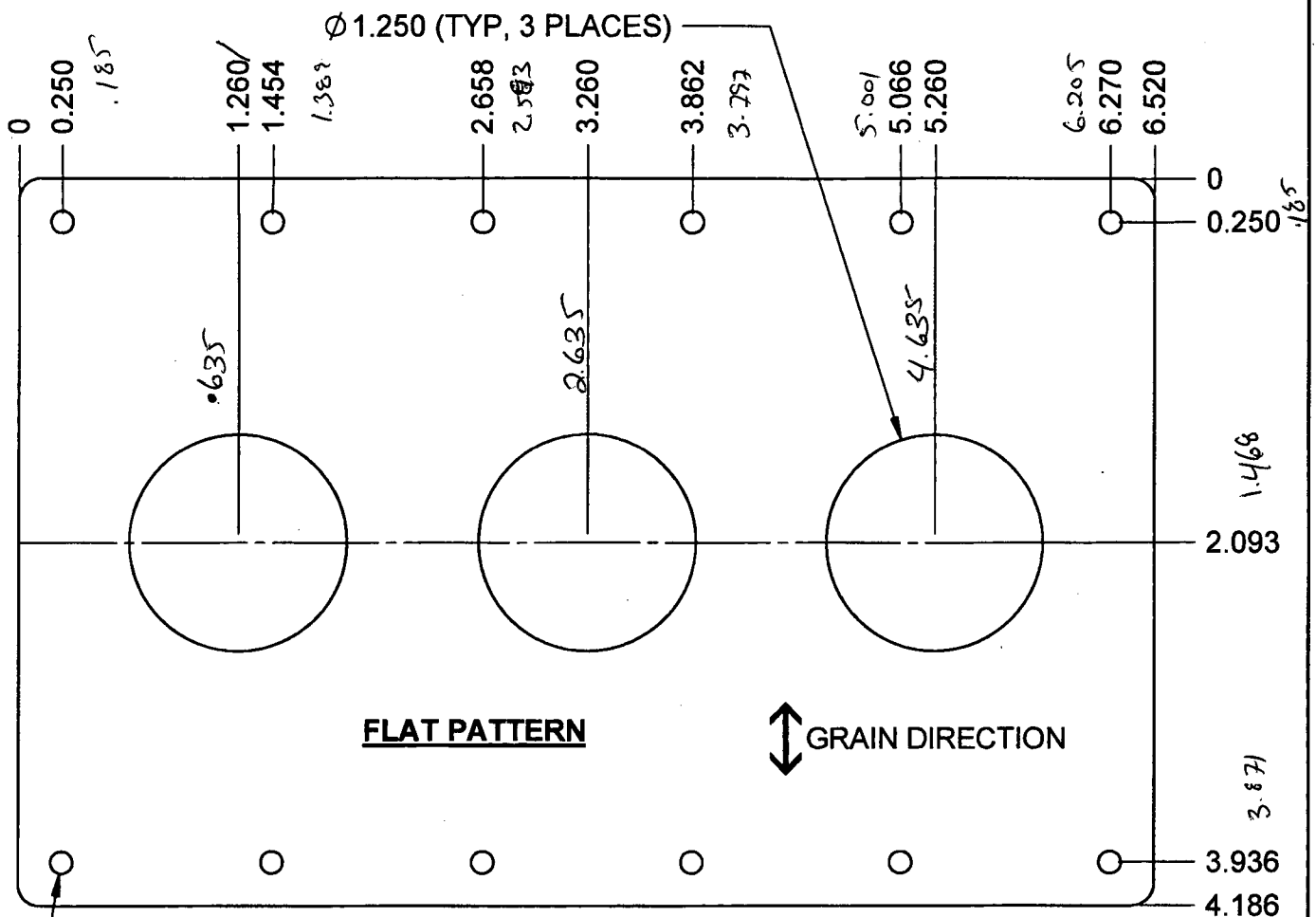
D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-3 STEP SPACER

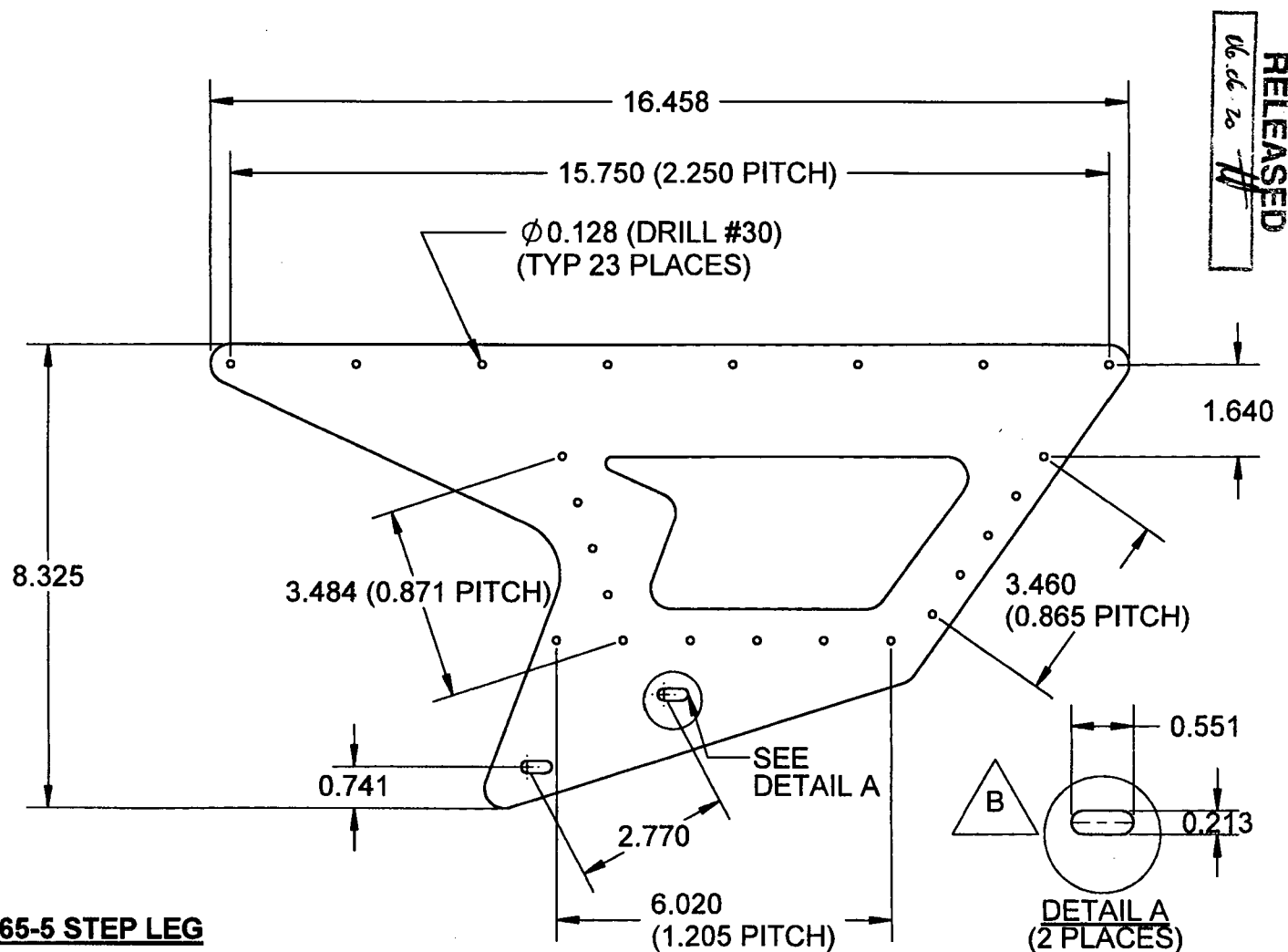
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWING BY	DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3065	REV. B SHEET 4 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:3



D3065-5 STEP LEG

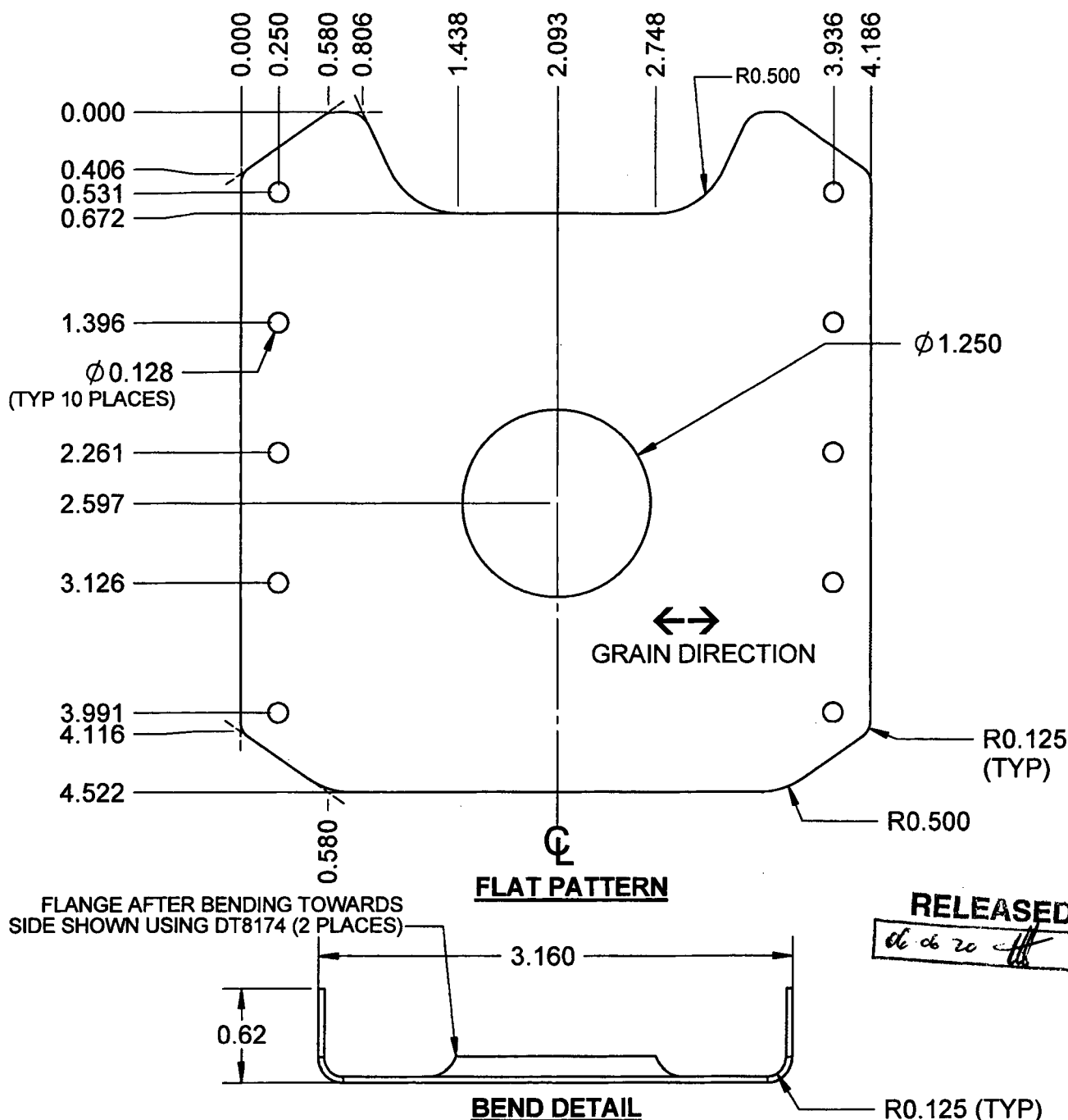
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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